

Work Order ID 45540

June 29, 2009 1:02:04 PM



Page 1

Item ID: D130-780-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD RH

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-042 CHG 001

8/9/09/03

Pho

110

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/9/09/03

tl

120

Packaging

0.00



Packaging

Memo

0.00

Packaging


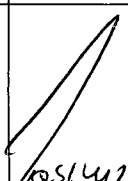
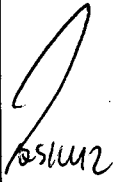


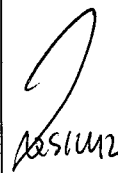

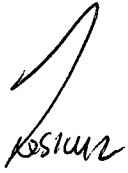
Identify and pack for shipping as per PPP D130-780-042 Location: _____ (PPP Rev: A)

9/6/13

Q254

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D130-780-042 PAR #: _____ Fault Category: fuel eng - correct NCR: Yes ☒ No ☐ DQA: 7 Date: 09-05-03
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: <u>45540</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|-------------------|--|---|---|---|---------------------------|---|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 9/9/03 | * p.d.c kit | Missing Parts From Pick List RL not correctly updated from Cock to intuitive |  | ADD missing part. DB015-3 +1 B* <u>B48238</u> | 9/9/03 SV | S 09/09/03 |  | S 09/09/03 |
| | | |  | update w/o + Bom to prevent from happen another time. also add copy of new bom for Ref. |  09/12/03 | S 09/09/03 |  | S 09/09/03 |
| | | |  | *Was Fixe |  09/09/03 | |  | |

NOTE: Date & initial all entries

Work Order ID 45540

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Item ID: D130-780-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: SPACEPOD RH

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

28-02-11

Picklist Print

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Page 1

Work Order ID: 45540

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH


Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|-----------|
| A3235-020-935  | | Purchased | No | | | | Each | 815.0000 | 1.0000 | | | SP |
| Washer - Countersunk A3235-020-935 ✓ | | Purchased | No | X (7x) | | | Each | 815.0000 | 8.0000 | | | SP |
| Washer - Countersunk AKS4-1032-130 ✓ | | Purchased | No | | | | Each | 1.0000 | 10.0000 | | | SP |
| Inserts AKS4-1032-130 ✓ | | Purchased | No | | | | Each | 1.0000 | 28.0000 | | | SP |
| Inserts AN3-10A ✓ | | Purchased | No | | | | Each | 127.0000 | 2.0000 | | | SP |
| Bolt AN3-3A ✓ | | Purchased | No | | | | Each | 229.0000 | 4.0000 | | | SP |
| Bolt AN3-6A ✓ | | Purchased | No | | | | Each | 138.0000 | 4.0000 | | | SP |
| Bolt AN525-10R7 ✓ | | Purchased | No | | | | Each | 268.0000 | 38.0000 | | | SP |
| Screw AN526-832R24 ✓ | | Purchased | No | | | | Each | 213.0000 | 4.0000 | | | SP |
| Screw | | | | | | | | | | | | 9/9/02 SP |

M106150 SP

M106150 SP

~~M10511~~ M10511 SP

M110511 SP

M11118 SP

M111925 SP

M112513 SP

M112314 SP

M116895 SP

9/9/02 SP

Picklist Print

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Page 2

Work Order ID: 45540

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| S AN526C832R14 | | Purchased | No | | | | Each | 1,051.000 | 8.0000 | | 10/19/16 SP | X |
| Screw | | | | | | | | | | | | |
| S AN5-5A | | Purchased | No | | | | Each | 116.0000 | 1.0000 | | | |
| Bolt | | | | | | | | | | | | |
| S AN960JD10 | | Purchased | No | | | | Each | 1,246.000 | 8.0000 | | | |
| Washer | | | | | | | | | | | | |
| S AN960JD516 | | Purchased | No | | | | Each | 1,603.000 | 3.0000 | | | |
| Washer | | | | | | | | | | | | |
| S D130-780-013RevA | | Manufactured | No | | | | Each | 5.0000 | 1.0000 | | | |
| SWITCH RELOCATION KIT | | | | | | | | | | | | |
| S D130-780-044RevA | | Manufactured | No | | | | Each | 0.0000 | 1.0000 | | | |
| SPACEPOD RH | | | | | | | | | | | | |
| D2237RevD1 | | Manufactured | No | | | | Each | 30.0000 | 2.0000 | | | |
| Striker Plate | | | | | | | | | | | | |
| S D3015-3RevB | | Manufactured | No | | | | Each | 435.0000 | 1.0000 | | | |
| Locknut | | | | | | | | | | | | |
| D3188-2MRevE | | Manufactured | No | | | | Each | 0.0000 | 1.0000 | | | |
| SPACEPOD BODY RH | | | | | | | | | | | | |

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 45540

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH










Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3538-1RevA ✓  | | Manufactured | No | | | | Each | 40.0000 | 2.0000 | | | |
| Hinge Bracket D3547-1RevA ✓  | | Manufactured | No | (K) * | | | Each | 20.0000 | 1.0000 | | | |
| Bracket D3550-1RevB ✓  | | Manufactured | No | | | | Each | 31.0000 | 1.0000 | | | |
| Strut D3554-7RevA ✓  | | Manufactured | No | (IX) * | | | Each | 81.0000 | 1.0000 | | | |
| Ball Stud D3798-042RevA ✓  | | Manufactured | No | | | | Each | 2.0000 | 1.0000 | | | |
| Spacepod Floor D3815-041RevA ✓  | | Manufactured | No | | | | Each | 17.0000 | 2.0000 | | | |
| Web Assembly D3837-1RevB ✓  | | Manufactured | No | | | | Each | 12.0000 | 1.0000 | | | |
| Decal D3837-4RevB ✓  | | Manufactured | No | | | | Each | 11.0000 | 1.0000 | | | |
| Decal MS20426AD4-5 ✓  | | Purchased | No | | | | Each | 7,958.000 | 4.0000 | | | |
| Rivet | | | | | | | | | | | | |

46753 SP

35455 K SP

45570 SP

37674

50X

50351 SP

45729 SP

46231

SP

46233

SP

4067

SP

02589 -044

546840

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2-179-642

MS20426404-5

MS1515H3

X

~~0237~~

X 0282-2

X 0282-1

MS104213

MS27039-1-5

X 0282-1

X 0282-1

X 0282-1

35432

4067 (4) 54

110397 2x 80

~~0237~~

43963 (1x) 50

45788 (1x) 50

111274 (2x) 50

111916 (3x) 50

46842 (4x) 50

50544 (5x) 50

47183 (6x) 50

Picklist Print

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Work Order ID: 45540

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH








Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------------------|----------|
| S MS21042L3 ✓  | | Purchased | No | | | | Each | 1,873.000 | 16.0000 | | M11274 | SL |
| Nut S MS21042L5 ✓  | | Purchased | No | | | | Each | 791.0000 | 1.0000 | | M111636 | SL |
| Nut MS21042L8  | | Purchased | No | | | | Each | 41.0000 | 4.0000 | | 14039 110017 | SL ? |
| S Nut MS24694-S67 ✓  | | Purchased | No | | | | Each | 167.0000 | 7.0000 | | M111968 | SL |
| S Screw MS24694-S69 ✓  | | Purchased | No | | | | Each | 27.0000 | 1.0000 | | 110153 | SL |
| S Screw NAS1149D0332J ✓  | | Purchased | No | | | | Each | 271.0000 | 16.0000 | | M110844 | SL 9/9/2 |
| Washer NAS1149DN832J ✓  | | Purchased | No | | | | Each | 107.0000 | 4.0000 | | 111359 | SL |
| WASHER | | | | | | | | | | | | |

① 3552-7 ✗ B 32644 SL 9/9/2
 AN960 POS16 B 118082 (37) SL
 NAS1149 POS63A 4-2-11
 PSL

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| | | | |
|---------------|-----|-----------------------|-----------|
| D 2586 | x 3 | latch (x1) | 47183 d |
| D 2585 | x 3 | mounting channel (x1) | 50544 BT |
| D 2237 | x 3 | striker plate (x1) | 46162 BT |
| D 2621 | x 3 | latch plate (x1) | 46842 BT |
| MS 21039.1.15 | x 3 | secret (x1) | 111916 BT |
| AN 9605010 | x 3 | washer (x3) | 111668 BT |
| MS 2104243 | x 3 | nut (x1) | 111274 BT |

hinge caps

D 2179 x 2 hinge backing plate (x1)

~~hinge caps~~

D 3548-1 x 1 Ball stud Backet (x1) no batch 30245 BT

AN 526 C 832 R 10 x 8 screws (x1)

AN 960508 x 8 1/4 washer (x2) 111578 BT

MS 21042408 x 8 1/4 nut (x1 x 6) 112243 BT

D 2228 x 1 Backing plate (x1)

D 2857-1 x 1 hinge (x1) 0 ✓

D 2857-2 x 1 hinge (x1) 0

D 3538-3 x 2 nylon washer (x2) 108335 BT

MS 21039-0811 x 2 screws (x2) 108335 BT

AN 526 C 832 R 10 x 4 screws (x2) 104916 BT

Ball studs

D 3554-7 x 2 ball stud (x1) 37674 BT

AN 96050516 x 2 washer (x1) 112082 BT

D 3015-3 x 2 yoke nut (x1) 48238 BT

Ball stud bracket

D 3549-1 ~~ball~~ x 1 ball stud bracket x 1 BT 44654

MS 20426AD4-6 x 2 rivet (+2) BT 105144

MS 20426AD4-5 x 12 rivet (+8) BT 4067

Spacer rod body x 1 B 47002801

IT 09-06-31

| *Status | Item ID | Rev | Name | Start Date | Quantity Per | UOM | Scrap % | Route Seq IC | Sort | Date Last Mod | Add Date | Comments |
|-------------------------------------|---------------|-----|-------------------------|------------|--------------|------|---------|--------------|------|-----------------|----------|-------------------|
| <input checked="" type="checkbox"/> | D130-780-044 | A | Spacepod Door Assemb... | 06/26/09 | 1.0000 | Each | 0 % | 110 | 1 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3188-2M | E | SPACEPOD BODY RH | 06/26/09 | 1.0000 | Each | 0 % | 110 | 3 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AKS4-1032-130 | | Inserts | 06/26/09 | 28.0000 | Each | 0 % | 110 | 4 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3837-4 | B | Decal | 06/26/09 | 1.0000 | Each | 0 % | 110 | 5 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D2237 | D1 | Striker Plate | 06/26/09 | 2.0000 | Each | 0 % | 110 | 6 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | MS20426AD4-5 | | Rivet | 06/26/09 | 4.0000 | Each | 0 % | 110 | 7 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3538-1 | A | Hinge Bracket | 06/26/09 | 2.0000 | Each | 0 % | 110 | 8 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AN526-832R24 | | Screw | 06/26/09 | 4.0000 | Each | 0 % | 110 | 9 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | NAS1149DN832J | | WASHER | 06/26/09 | 4.0000 | Each | 0 % | 110 | 10 | 07/06/09 10:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | MS21042L08 | | Nut | 07/06/09 | 4.0000 | Each | 0 % | 110 | 11 | 07/06/09 12:... | 07/06/09 | d |
| <input checked="" type="checkbox"/> | D3815-041 | A | Web Assembly | 06/26/09 | 2.0000 | Each | 0 % | 160 | 12 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3837-1 | B | Decal | 06/26/09 | 1.0000 | Each | 0 % | 160 | 13 | 07/13/09 3:0... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3798-042 | A | Spacepod Floor | 06/26/09 | 1.0000 | Each | 0 % | 160 | 14 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3547-1 | A | Bracket | 06/26/09 | 1.0000 | Each | 0 % | 160 | 15 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3550-1 | B | Strut | 06/26/09 | 1.0000 | Each | 0 % | 160 | 16 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3554-7 | A | Ball Stud | 06/26/09 | 1.0000 | Each | 0 % | 160 | 17 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D3015-3 | B | Locknut | 06/26/09 | 1.0000 | Each | 0 % | 160 | 18 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AN3-3A | | Bolt | 06/26/09 | 4.0000 | Each | 0 % | 160 | 19 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AN3-6A | | Bolt | 06/26/09 | 4.0000 | Each | 0 % | 160 | 20 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AN3-10A | | Bolt | 06/26/09 | 2.0000 | Each | 0 % | 160 | 21 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AN5-5A | | Bolt | 06/26/09 | 1.0000 | Each | 0 % | 160 | 22 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AN525-10R7 | | Screw | 06/26/09 | 38.0000 | Each | 0 % | 160 | 23 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | MS24694-S67 | | Screw | 06/26/09 | 7.0000 | Each | 0 % | 160 | 24 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AN526C832R14 | | Screw | 06/26/09 | 8.0000 | Each | 0 % | 160 | 25 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | MS24694-S69 | | Screw | 06/26/09 | 1.0000 | Each | 0 % | 160 | 26 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | A3235-020-935 | | Washer - Countersunk | 06/26/09 | 8.0000 | Each | 0 % | 160 | 27 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | NAS1149D0363J | | Washer | 07/06/09 | 8.0000 | Each | 0 % | 160 | 28 | 07/06/09 12:... | 07/06/09 | d |
| <input checked="" type="checkbox"/> | NAS1149D0332J | | Washer | 06/26/09 | 16.0000 | Each | 0 % | 160 | 29 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | NAS1149D0563J | | Washer | 07/06/09 | 3.0000 | Each | 0 % | 160 | 30 | 07/06/09 12:... | 07/06/09 | d |
| <input checked="" type="checkbox"/> | MS21042L3 | | Nut | 06/26/09 | 16.0000 | Each | 0 % | 160 | 31 | 07/06/09 12:... | 06/26/09 | d |

| Status | Item ID | Rev | Name | Start Date | Quantity Per | UOM | Scrap % | Route Seq IC | Sort | Date Last Mod | Add Date | Comments |
|-------------------------------------|---------------|-----|----------------------|------------|--------------|------|---------|--------------|------|-----------------|----------|-------------------|
| <input checked="" type="checkbox"/> | MS21042L5 | | Nut | 06/26/09 | 1.0000 | Each | 0 % | 160 | 32 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | AKS4-1032-130 | | Inserts | 06/26/09 | 10.0000 | Each | 0 % | 160 | 33 | 07/06/09 12:... | 06/26/09 | d |
| <input checked="" type="checkbox"/> | D130-780-013 | A | SWITCH RELOCATION... | 06/26/09 | 1.0000 | Each | 0 % | 160 | 34 | 07/13/09 4:1... | 06/26/09 | d |

5.0 PARTS LIST

| -041 | -042 | -043 | -044 | -011 | -013 | Part Number | Description |
|------|------|------|------|------|------|---------------|-------------------------|
| X | | | | | | D130-780-041 | SPACEPOD™ LH, EC 130 B4 |
| | X | | | | | D130-780-042 | SPACEPOD™ RH, EC 130 B4 |
| 1 | | X | | | | D130-780-043 | DOOR ASSEMBLY, LH |
| | (1) | | X | | | D130-780-044 | DOOR ASSEMBLY, RH |
| 1 | | | | X | | D130-780-011 | AFT LH DOOR HINGE KIT |
| 1 | (1) | | | X | X | D130-780-013 | SWITCH RELOCATION KIT |
| | | | | | | | |
| 2 | (2) | | | | X | D3815-041 | WEB ASSEMBLY |
| | | | | | | D2464-0360 | NEOPRENE SEAL |
| | | 1 | (1) | | X | D2589 | KEYS, KEY CHAIN |
| 1 | (1) | | | | X | D3837-1 | DECAL |
| 1 | (1) | | | | | D3015-3 | LOCK NUT |
| | | 1 | | | | D3186-3 | SPACEPOD™ DOOR, LH |
| | | | (1) | | | D3186-4 | SPACEPOD™ DOOR, RH |
| 1 | | | | | | D3798-041 | FLOOR |
| | (1) | | | | X | D3798-042 | FLOOR |
| 1 | | | | | | D3188-5 | SPACEPOD™ BODY |
| | (1) | | | | | D3188-6 | SPACEPOD™ BODY |
| 1 | (1) | | | | | D3547-1 | BRACKET |
| 1 | (1) | | | | X | D3550-1 | STRUT |
| | | 1 | (1) | | X | D3552-7 | GAS SPRING |
| 1 | (1) | | | | | D3554-7 | BALL STUD |
| | | | | | | | |
| 4 | (4) | | | | X | AN3-3A | BOLT |
| 4 | (4) | | | | X | AN3-6A | BOLT |
| 2 | (2) | | | | X | AN3-10A | BOLT |
| 1 | (1) | | | | X | AN5-5A | BOLT |
| 38 | (38) | | | | X | AN525-10R7 | SCREW |
| 8 | (8) | | | | X | AN526C832R14 | SCREW |
| 7 | (7) | | | | X | MS24694S67 | SCREW |
| 1 | (1) | | | | X | MS24694S69 | SCREW |
| | | 2 | (2) | | | MS27039-0811 | SCREW |
| 8 | (8) | | | | X | A3235-020-935 | WASHER |
| 8 | (8) | | | | X | NAS1149D0363J | WASHER |
| 16 | (16) | | | | X | NAS1149D0332J | WASHER |
| | | 4 | (4) | | | NAS1149DN832J | WASHER |
| 3 | (3) | | | | X | NAS1149D0563J | WASHER |
| | | 2 | (2) | | | NAS1515H3 | NYLON WASHER |
| | | 2 | (2) | | X | MS21042L08 | NUT |
| 16 | (16) | | | | X | MS21042L3 | NUT (or MS21042-3) |
| 1 | (1) | | | | X | MS21042L5 | NUT |
| 10 | (10) | | | | X | AKS7-1032-130 | INSERT |
| 28** | 28** | | | | | AKS7-1032-130 | INSERT |
| | | | | | | | |
| | | | | | 2 | D3819-1 | MALE SPADE CONNECTOR |
| | | | | | 2 | D3597-1 | FEMALE SPADE CONNECTOR |

REFERENCE ONLY

42.11 051

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Revision: A

Date: 08.10.07

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| -041 | -042 | -043 | -044 | -011 | -013 | Part Number | Description |
|------|------|------|------|------|-------|----------------|----------------------------|
| | | | | | 1 | D3598-2-096 | EXPANDABLE SLEEVE |
| | | | | | 24 | D3599-1 | TIE-WRAP |
| | | | | | 24 | D3600-1 | TIE-WRAP MOUNT |
| | | | | | 24 FT | M22759/41-22-9 | WIRE |
| | | 1* | 1* | | | D2464-1250 | NEOPRENE SEAL |
| 1** | | 1* | | | | D3837-3 | DECAL |
| | 1** | | 1* | | | D3837-4 | DECAL |
| | | 2* | 2* | | | D2586 | LATCH |
| | | 2* | 2* | | | D2585 | MOUNTING CHANNEL |
| | | 2* | 2* | | | D2621 | LATCH PLATE |
| | | 2* | 2* | | | MS27039-1-15 | SCREW |
| | | 2* | 2* | | | NAS1149D0363J | WASHER |
| | | 2* | 2* | | | MS21042L3 | NUT (or MS21042-3) |
| | | 1* | 1* | | | D2857-1 | HINGE BRACKET |
| | | 1* | 1* | | | D2857-2 | HINGE BRACKET |
| | | 2* | 2* | | | D2228 | BACKING PLATE |
| | | 8* | 8* | | | AN526C832R10 | SCREW |
| | | 8* | 8* | | | NAS1149DN832J | WASHER |
| | | 8* | 8* | | | MS21042L08 | NUT |
| | | 1* | 1* | | | D3557-1 | BRACKET |
| | | 2* | 2* | | | D2228 | BACKING PLATE |
| | | 1* | 1* | | | D3554-7 | BALL STUD |
| | | 1* | 1* | | | NAS1149D0563J | WASHER |
| | | 1* | 1* | | | D3015-3 | LOCK NUT |
| | | 2* | 2* | | | AN526C832R14 | SCREW |
| | | 2* | 2* | | | AN526C832R10 | SCREW |
| | | 4* | 4* | | | NAS1149DN832J | WASHER |
| | | 4* | 4* | | | MS21042L08 | NUT |
| 2** | 2** | | | | | D2237 | STRIKER PLATE |
| 4** | 4** | | | | | MS20426AD4-5 | RIVET |
| 2** | 2** | | | | | D3538-1 | HINGE BRACKET |
| 2** | 2** | | | | | D2179 | HINGE BRACKET PLATE |
| 4** | 4** | | | | | AN526C832R24 | SCREW |
| 4** | 4** | | | | | NAS1149DN832J | WASHER |
| 4** | 4** | | | | | MS21042L08 | NUT |
| | | | | 1 | | D3813-041 | HINGE ASSEMBLY, UPPER DOOR |
| | | | | 1 | | D3813-043 | HINGE ASSEMBLY, LOWER DOOR |
| | | | | 2*** | | D3518-3 | ROD END |
| | | | | 2*** | | NAS509-6 | NUT |
| | | | | 1 | | D3814-1 | HINGE, UPPER AIRFRAME |
| | | | | 1 | | D3814-3 | HINGE, LOWER AIRFRAME |

REFERENCE ONLY

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Revision: A

Date: 08.10.07

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| -041 | -042 | -043 | -044 | -011 | -013 | Part Number | Description |
|------|------|------|------|------|------|---------------|--------------|
| | | | | 2 | | D3816-1 | SPACER |
| | | | | 4 | | D3816-3 | SPACER |
| | | | | 1 | | D3817-041 | ANCHOR PLATE |
| | | | | 2 | | AN3-5A | BOLT |
| | | | | 3 | | AN3-7A | BOLT |
| | | | | 2 | | AN310-4 | CASTLE NUT |
| | | | | 2 | | AN4-17 | BOLT |
| | | | | 2 | | AN970-4 | WASHER |
| | | | | 5 | | MS21042L3 | NUT |
| | | | | 2 | | MS24665-212 | COTTER PIN |
| | | | | 3 | | MS24694S46 | SCREW |
| | | | | 8 | | NAS1149D0363J | WASHER |
| | | | | 2 | | NAS1149D0463J | WASHER |
| | | | | | | | |
| | | | | 1 | | D3552-7 | GAS SPRING |
| | | | | 2 | | D3622-1 | BALL STUD |
| | | | | 1 | | D3820-1 | DOOR SUPPORT |
| | | | | 2 | | MS21042L5 | NUT |
| | | | | 2 | | NAS1149D0563J | WASHER |
| | | | | | | | |

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

REFERENCE ONLY

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Revision: **A**
Date: 08.10.07

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Spacopod RH B4618013

✓ NAS 1515 H3 x 2 washers w 110379
 ✓ MS 27039-0811 x 2 screws w 110379
 AN 526 C 832 R24 x4 screws w 104603
 03538-1 x2 hinge w 46473
 02179 x2 back plate 35432
 02237 x2 still plate 46162
 MS 20426AD4-4 rivet 15511
 43235-020-935 x 8 washers 106150
 AK 57-1032-130 x 28 insert 111529

AN 9605010 x 2 washers M 111668 (NAS 1149D03635)
 AN 96050516 x 1 washer M 111279 (NAS 1149D05633)
 AN 526 C 832 R12 x 2 screws M 107285
 MS 21042608 x 26 nut M 112243
 AN 960508 x 26 washers M 111578

Date:
User:Wednesday, 25/03/2009 11:52:21 AM
Julie Dawson

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|---------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DOOR ASSEMBLY, RH |
| Job Number | : 45540 | | |
| Estimate Number | : 13764 | | |
| P.O. Number | : | Part Number | : D130780044 |
| This Issue | : 25/03/2009 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : IIN-D130-780 |
| First Issue | : 05/02/2009 | Project Number | : N/A |
| Previous Run | : 45539 | Drawing Revision | : A |
| | Type | Material | : |
| | : PURCHASED PARTS | Due Date | : 28/02/2009 |
| Written By | : | Qty: | 1 Um: Each |
| Checked & Approved By | : <u>JUL 09.03.25</u> | | |
| Comment | : Est Rev:A 09-02-03 new issue DD verified by:JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP D130-780-044 CHG 001

2.0

D31864

Spacepod Door, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Door, RH
batch: _____

3.0

D24641250

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Neoprene Seal
batch: _____

4.0

D38374

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Decal
batch: 46233

5.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Door Latch
batch: 47193

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:52:21 AM
User: Julie.Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, RH

Job Number: 45540

Part Number: D130780044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Channel

batch: 50544

7.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate, 350 Spacepod

batch: 116842

8.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 111914

9.0

NAS1149D0363J

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch:

10.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: 111274

11.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: 45788

12.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: 43363

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:52:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, RH

Job Number: 45540

Part Number: D130780044

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-------|---------------|
| 13.0 | D2228 | Bracket Plate |
|------|-------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket Plate

batch: 30679

| | | |
|------|--------------|-------|
| 14.0 | AN526C832R10 | Screw |
|------|--------------|-------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: 104603

| | | |
|------|---------------|--------|
| 15.0 | NAS1149DN832J | Washer |
|------|---------------|--------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: 11359

| | | |
|------|------------|-----|
| 16.0 | MS21042L08 | Nut |
|------|------------|-----|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: 112243

| | | |
|------|--------|---------|
| 17.0 | D35571 | Bracket |
|------|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: 46887

| | | |
|------|-------|---------------|
| 18.0 | D2228 | Bracket Plate |
|------|-------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket Plate

batch: 30679

| | | |
|------|--------|-----------|
| 19.0 | D35547 | Ball Stud |
|------|--------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ball Stud

batch: 37674

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:52:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, RH

Job Number: 45540

Part Number: D130780044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

NAS1149D0563J

Washer



4-2-11
Reference



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: M112082

21.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Locknut

batch: 48278

22.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: N04916

23.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch:

24.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch:

25.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch:

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



910-7

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg

4T 09 06-31

| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|------|---|----------------------|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 09/09/01 | 105 | CUT 0.6" x 2.0" CHAMFER ON BOTTOM- INBOARD EDGE. 90Z CLOTH B/N <u>111166</u> HYSOL 956 B/N <u>112167</u> | RT 09 08 31 | | | CP 09.09.01 PS/0472 | S 02/09/01 | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:52:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, RH

Job Number: 45540

Part Number: D130780044

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sort 10/10/1 (4)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

pick kit:

29.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Keys, Key Chain, 350 Hinge

30.0

D35527

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Prop

batch: _____

31.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

32.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

33.0

NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 25/03/2009 11:52:22 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY, RH

Job Number: 45540

Part Number: D130780044

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|------------|-----|
| 34.0 | MS21042L08 | Nut |
|------|------------|-----|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
batch: _____

| | | |
|------|-----|------------------------------------|
| 35.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|------|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

| | | |
|------|-------------|-----------------------|
| 36.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D130-780-044
Location: _____
PPP Rev: _____

| | | |
|------|------|------------------------------|
| 37.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5.0 PARTS LIST

| -041 | -042 | -043 | -044 | -011 | -013 | Part Number | Description |
|------|------|------|------|------|------|---------------|-------------------------|
| X | | | | | | D130-780-041 | SPACEPOD™ LH, EC 130 B4 |
| | X | | | | | D130-780-042 | SPACEPOD™ RH, EC 130 B4 |
| 1 | | X | | | | D130-780-043 | DOOR ASSEMBLY, LH |
| | 1 | | X | | | D130-780-044 | DOOR ASSEMBLY, RH |
| 1 | | | | X | | D130-780-011 | AFT LH DOOR HINGE KIT |
| 1 | 1 | | | | X | D130-780-013 | SWITCH RELOCATION KIT |
| | | | | | | | |
| | | | | | | | |
| 2 | 2 | | | | | D3815-041 | WEB ASSEMBLY |
| | | | | | | D2464-0360 | NEOPRENE SEAL |
| | | 1 | 1 | | | D2589 | KEYS, KEY CHAIN |
| 1 | 1 | | | | | D3837-1 | DECAL |
| 1 | 1 | | | | | D3015-3 | LOCK NUT |
| | | 1 | | | | D3186-3 | SPACEPOD™ DOOR, LH |
| | | | 1 | | | D3186-4 | SPACEPOD™ DOOR, RH |
| 1 | | | | | | D3798-041 | FLOOR |
| | 1 | | | | | D3798-042 | FLOOR |
| 1 | | | | | | D3188-5 | SPACEPOD™ BODY |
| | 1 | | | | | D3188-6 | SPACEPOD™ BODY |
| 1 | 1 | | | | | D3547-1 | BRACKET |
| 1 | 1 | | | | | D3550-1 | STRUT |
| | | 1 | 1 | | | D3552-7 | GAS SPRING |
| 1 | 1 | | | | | D3554-7 | BALL STUD |
| | | | | | | | |
| 4 | 4 | | | | | AN3-3A | BOLT |
| 4 | 4 | | | | | AN3-6A | BOLT |
| 2 | 2 | | | | | AN3-10A | BOLT |
| 1 | 1 | | | | | AN5-5A | BOLT |
| 38 | 38 | | | | | AN525-10R7 | SCREW |
| 8 | 8 | | | | | AN526C832R14 | SCREW |
| 7 | 7 | | | | | MS24694S67 | SCREW |
| 1 | 1 | | | | | MS24694S69 | SCREW |
| | | 2 | 2 | | | MS27039-0811 | SCREW |
| 8 | 8 | | | | | A3235-020-935 | WASHER |
| 8 | 8 | | | | | NAS1149D0363J | WASHER |
| 16 | 16 | | | | | NAS1149D0332J | WASHER |
| | | 4 | 4 | | | NAS1149DN832J | WASHER |
| 3 | 3 | | | | | NAS1149D0563J | WASHER |
| | | 2 | 2 | | | NAS1515H3 | NYLON WASHER |
| | | 2 | 2 | | | MS21042L08 | NUT |
| 16 | 16 | | | | | MS21042L3 | NUT (or MS21042-3) |
| 1 | 1 | | | | | MS21042L5 | NUT |
| 10 | 10 | | | | | AKS7-1032-130 | INSERT |
| 28** | 28** | | | | | AKS7-1032-130 | INSERT |
| | | | | | | | |
| | | | | | 2 | D3819-1 | MALE SPADE CONNECTOR |
| | | | | | 2 | D3597-1 | FEMALE SPADE CONNECTOR |

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Revision: A

Date: 08:10.07.10

455 70

| -041 | -042 | -043 | -044 | -011 | -013 | Part Number | Description |
|------|------|------|------|------|-------|----------------|----------------------------|
| | | | | | 1 | D3598-2-096 | EXPANDABLE SLEEVE |
| | | | | | 24 | D3599-1 | TIE-WRAP |
| | | | | | 24 | D3600-1 | TIE-WRAP MOUNT |
| | | | | | 24 FT | M22759/41-22-9 | WIRE |
| | | 1* | 1* | | | D2464-1250 | NEOPRENE SEAL |
| 1** | | 1* | | | | D3837-3 | DECAL |
| | 1** | | 1* | | | D3837-4 | DECAL |
| | | 2* | 2* | | | D2586 | LATCH |
| | | 2* | 2* | | | D2585 | MOUNTING CHANNEL |
| | | 2* | 2* | | | D2621 | LATCH PLATE |
| | | 2* | 2* | | | MS27039-1-15 | SCREW |
| | | 2* | 2* | | | NAS1149D0363J | WASHER |
| | | 2* | 2* | | | MS21042L3 | NUT (or MS21042-3) |
| | | 1* | 1* | | | D2857-1 | HINGE BRACKET |
| | | 1* | 1* | | | D2857-2 | HINGE BRACKET |
| | | 2* | 2* | | | D2228 | BACKING PLATE |
| | | 8* | 8* | | | AN526C832R10 | SCREW |
| | | 8* | 8* | | | NAS1149DN832J | WASHER |
| | | 8* | 8* | | | MS21042L08 | NUT |
| | | 1* | 1* | | | D3557-1 | BRACKET |
| | | 2* | 2* | | | D2228 | BACKING PLATE |
| | | 1* | 1* | | | D3554-7 | BALL STUD |
| | | 1* | 1* | | | NAS1149D0563J | WASHER |
| | | 1* | 1* | | | D3015-3 | LOCK NUT |
| | | 2* | 2* | | | AN526C832R14 | SCREW |
| | | 2* | 2* | | | AN526C832R10 | SCREW |
| | | 4* | 4* | | | NAS1149DN832J | WASHER |
| | | 4* | 4* | | | MS21042L08 | NUT |
| 2** | 2** | | | | | D2237 | STRIKER PLATE |
| 4** | 4** | | | | | MS20426AD4-5 | RIVET |
| 2** | 2** | | | | | D3538-1 | HINGE BRACKET |
| 2** | 2** | | | | | D2179 | HINGE BRACKET PLATE |
| 4** | 4** | | | | | AN526C832R24 | SCREW |
| 4** | 4** | | | | | NAS1149DN832J | WASHER |
| 4** | 4** | | | | | MS21042L08 | NUT |
| | | | | 1 | | D3813-041 | HINGE ASSEMBLY, UPPER DOOR |
| | | | | 1 | | D3813-043 | HINGE ASSEMBLY, LOWER DOOR |
| | | | | 2*** | | D3518-3 | ROD END |
| | | | | 2*** | | NAS509-6 | NUT |
| | | | | 1 | | D3814-1 | HINGE, UPPER AIRFRAME |
| | | | | 1 | | D3814-3 | HINGE, LOWER AIRFRAME |

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Revision: A WITHOUT NOTICE
 Date: 08.10.07 WORK ORDER
 NO. 455730

| -041 | -042 | -043 | -044 | -011 | -013 | Part Number | Description |
|------|------|------|------|------|------|---------------|--------------|
| | | | | 2 | | D3816-1 | SPACER |
| | | | | 4 | | D3816-3 | SPACER |
| | | | | 1 | | D3817-041 | ANCHOR PLATE |
| | | | | 2 | | AN3-5A | BOLT |
| | | | | 3 | | AN3-7A | BOLT |
| | | | | 2 | | AN310-4 | CASTLE NUT |
| | | | | 2 | | AN4-17 | BOLT |
| | | | | 2 | | AN970-4 | WASHER |
| | | | | 5 | | MS21042L3 | NUT |
| | | | | 2 | | MS24665-212 | COTTER PIN |
| | | | | 3 | | MS24694S46 | SCREW |
| | | | | 8 | | NAS1149D0363J | WASHER |
| | | | | 2 | | NAS1149D0463J | WASHER |
| | | | | | | | |
| | | | | 1 | | D3552-7 | GAS SPRING |
| | | | | 2 | | D3622-1 | BALL STUD |
| | | | | 1 | | D3820-1 | DOOR SUPPORT |
| | | | | 2 | | MS21042L5 | NUT |
| | | | | 2 | | NAS1149D0563J | WASHER |
| | | | | | | | |

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: **A**

Date: 08.10.07



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| CHECKED | CE | APPROVED | [Signature] | HAWKESBURY, ONTARIO, CANADA |
| DATE | 07.04.02 | TITLE | D3188 | REV. E |
| | | | SPACEPOD BODY | SHEET 1 OF 11 |
| A | 03.04.03 | NEW ISSUE | | SCALE |
| B | 06.10.06 | UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7 | | |
| C | 06.12.13 | REMOVED D0600-XXX LABELS | | |
| D | 07.02.22 | UPDATE DIMENSIONS | | |
| E | 07.04.02 | ADD HYSOL/FIBER OPTION ON SHEET 11 | | |

GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

| PART | LAYUP | TRIM AND DRILL |
|----------------|--------|----------------|
| D3188-1M/-1/-5 | DT8003 | DT8501 |
| D3188-2M/-2/-6 | DT8004 | DT8502 |
| D3188-3M/-3/-7 | DT8500 | DT8501 |

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

- 7) ALL DIMENSIONS ARE IN INCHES

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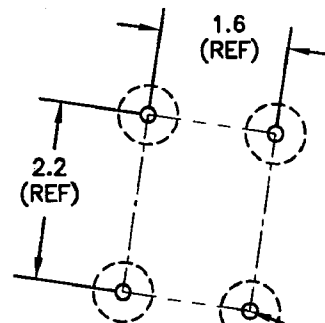
NOTES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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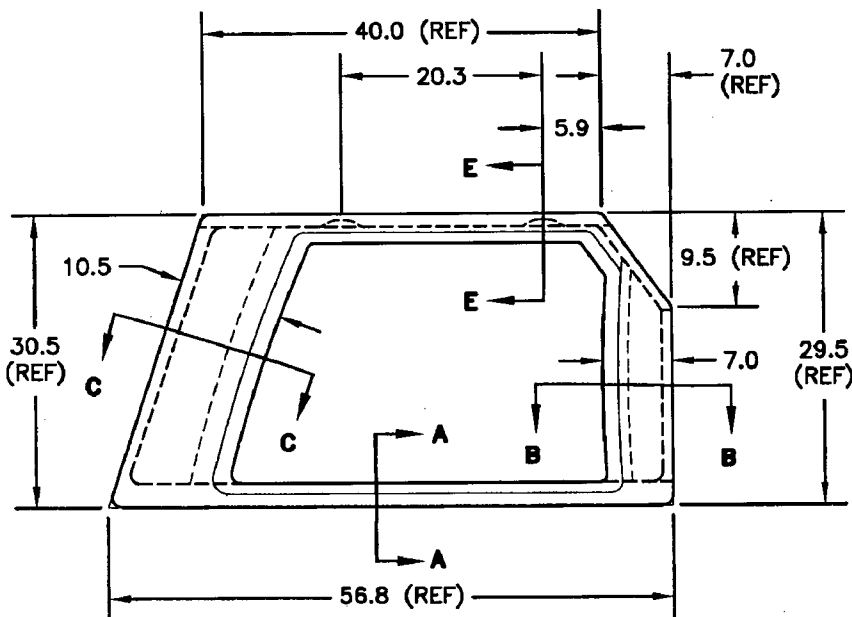
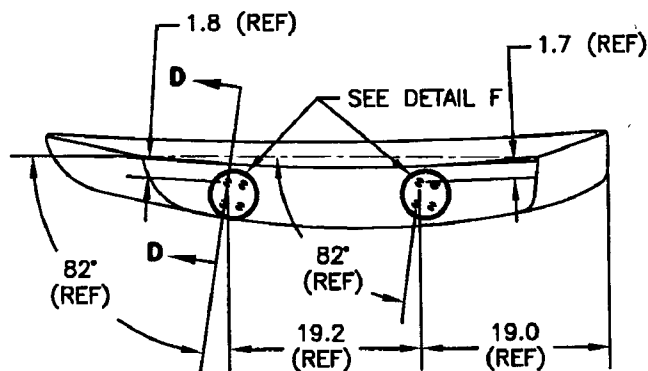
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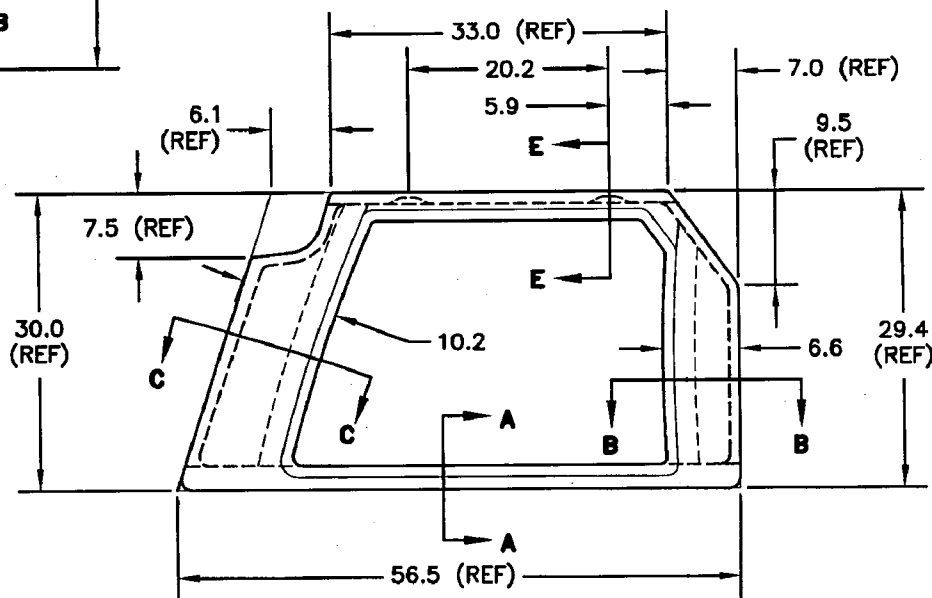
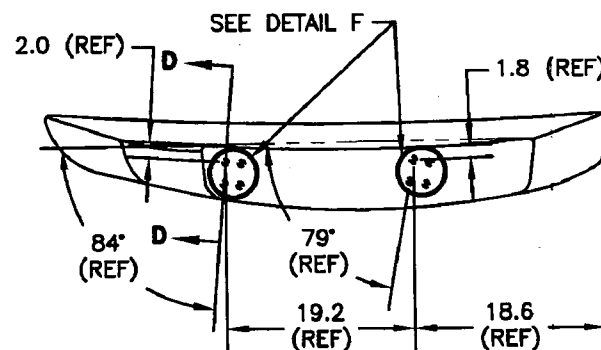
INSTALL
D2213 SPACER
(8 PLACES)
(SEE SECTION D-D)



DETAIL F



D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

| | | |
|----------------------|------------------------|---|
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| DATE 07.04.02 | TITLE SPACEPOD BODY | SHEET 2 OF 11 |
| | | SCALE NTS |

D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

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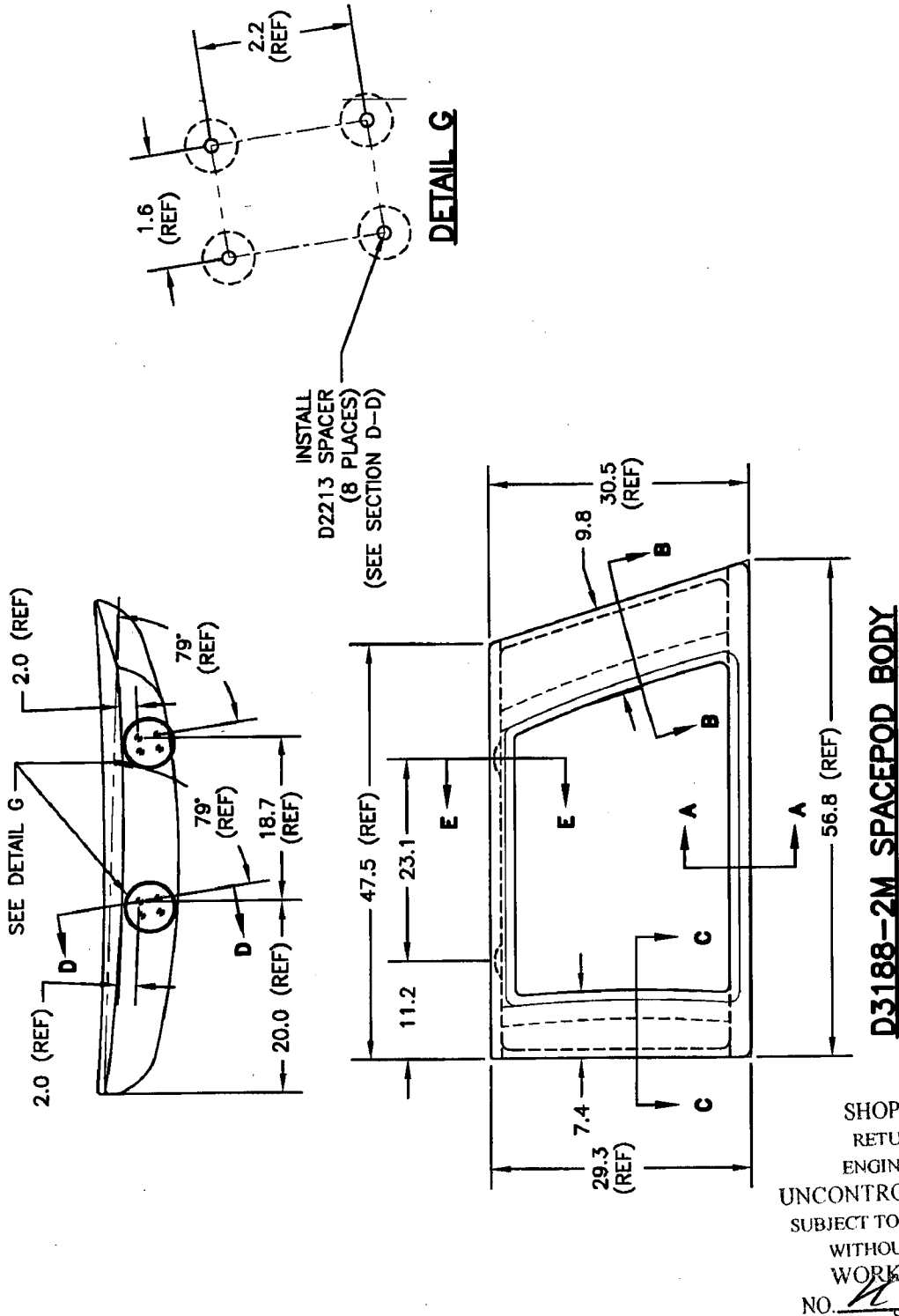
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| DATE 07.04.02 | TITLE SPACEPOD BODY | | SCALE NTS |

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07.04.01 *[Signature]*

D3188-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.

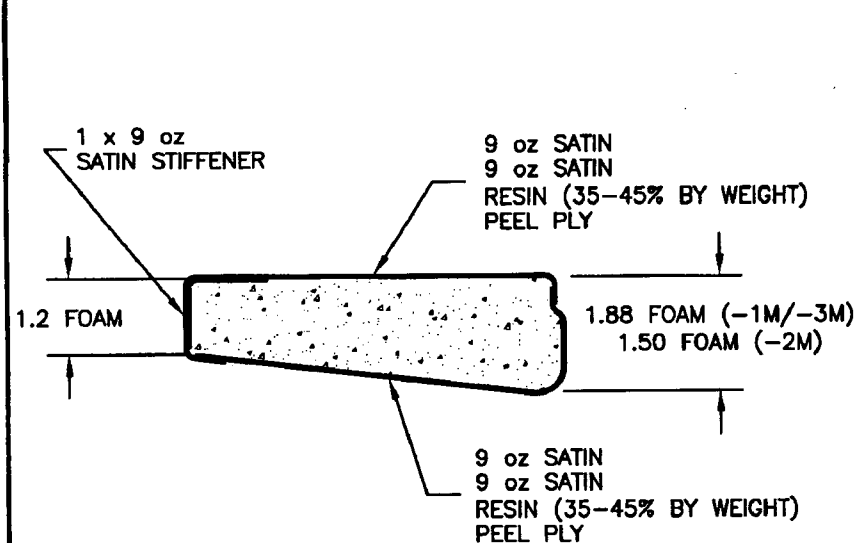
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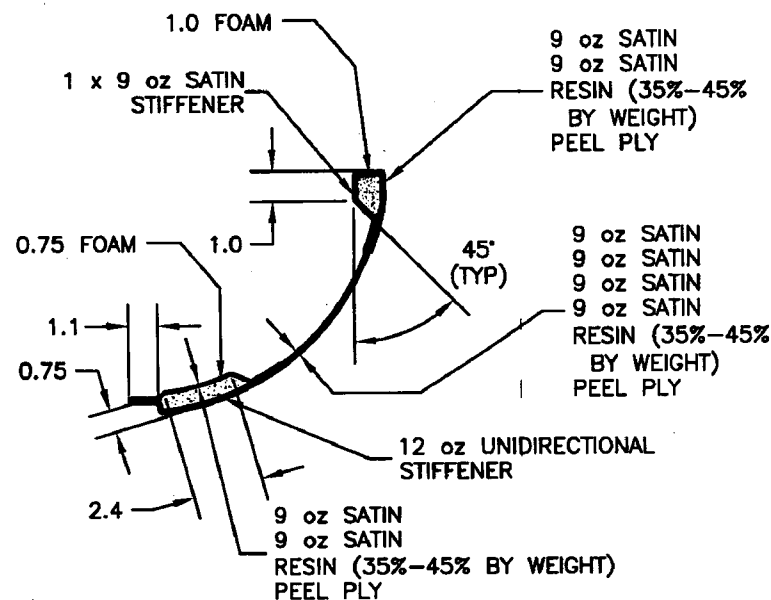
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| DATE | 07.04.02 | TITLE | SPACEPOD BODY | SHEET 4 OF 11 | REV. E |
| | | | | SCALE | NTS |

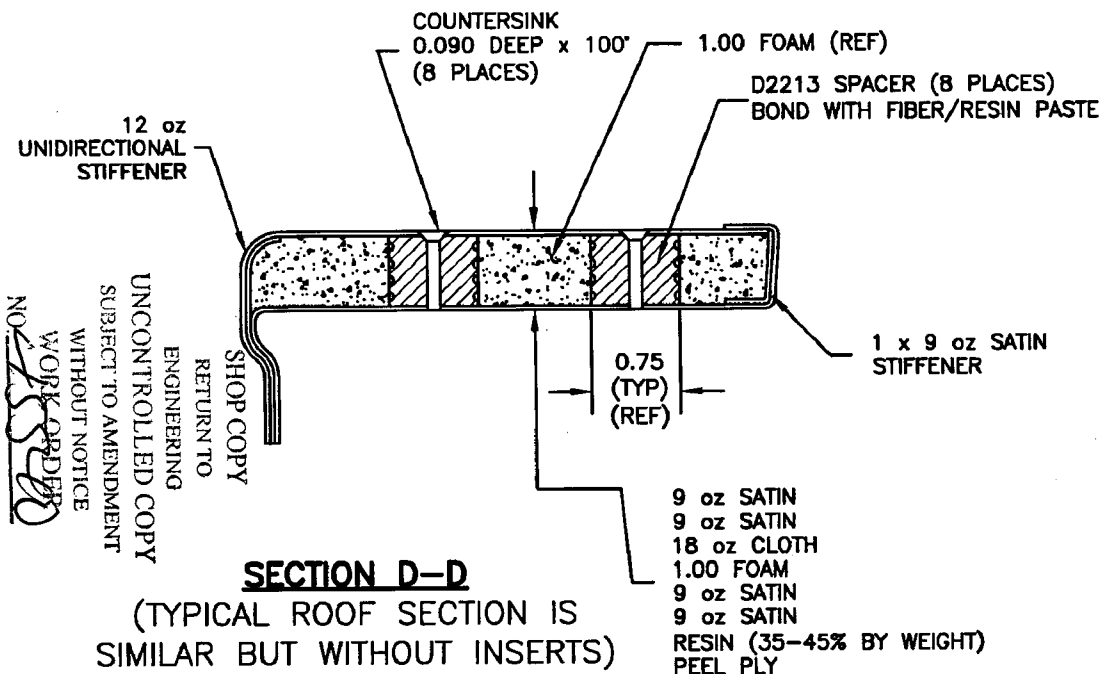
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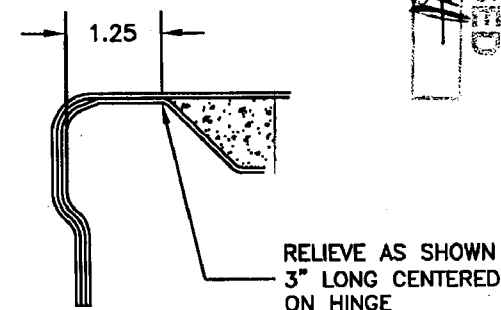
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

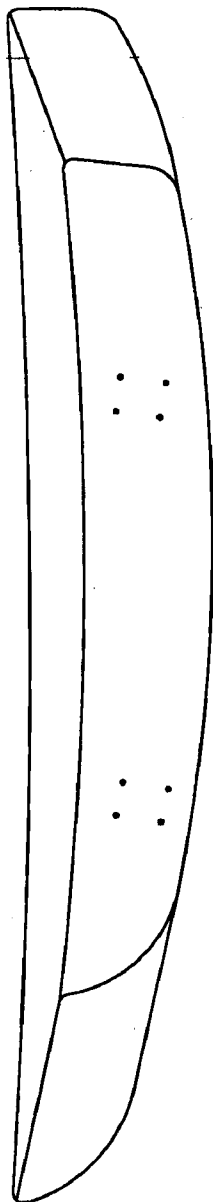
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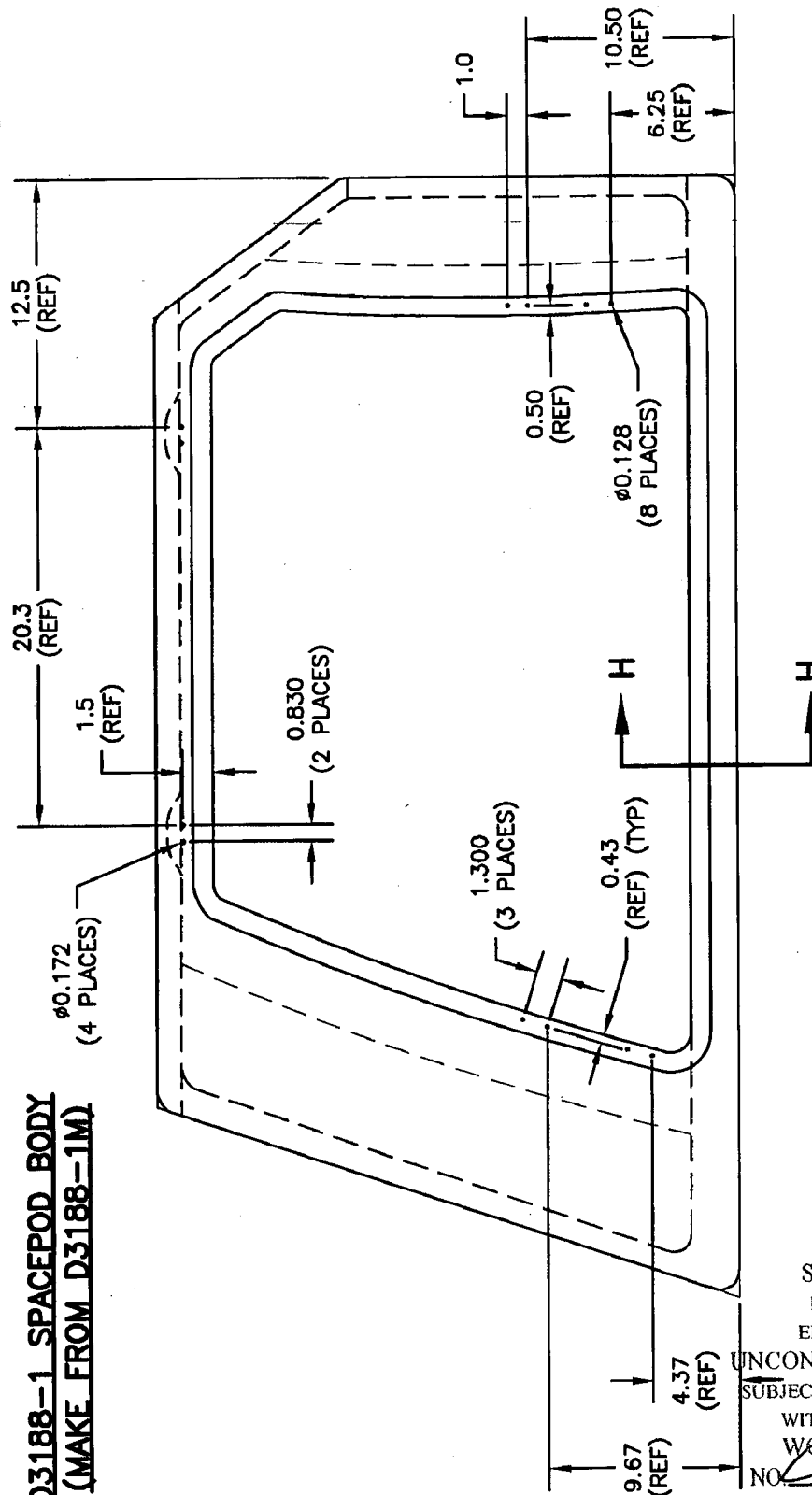
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**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEW

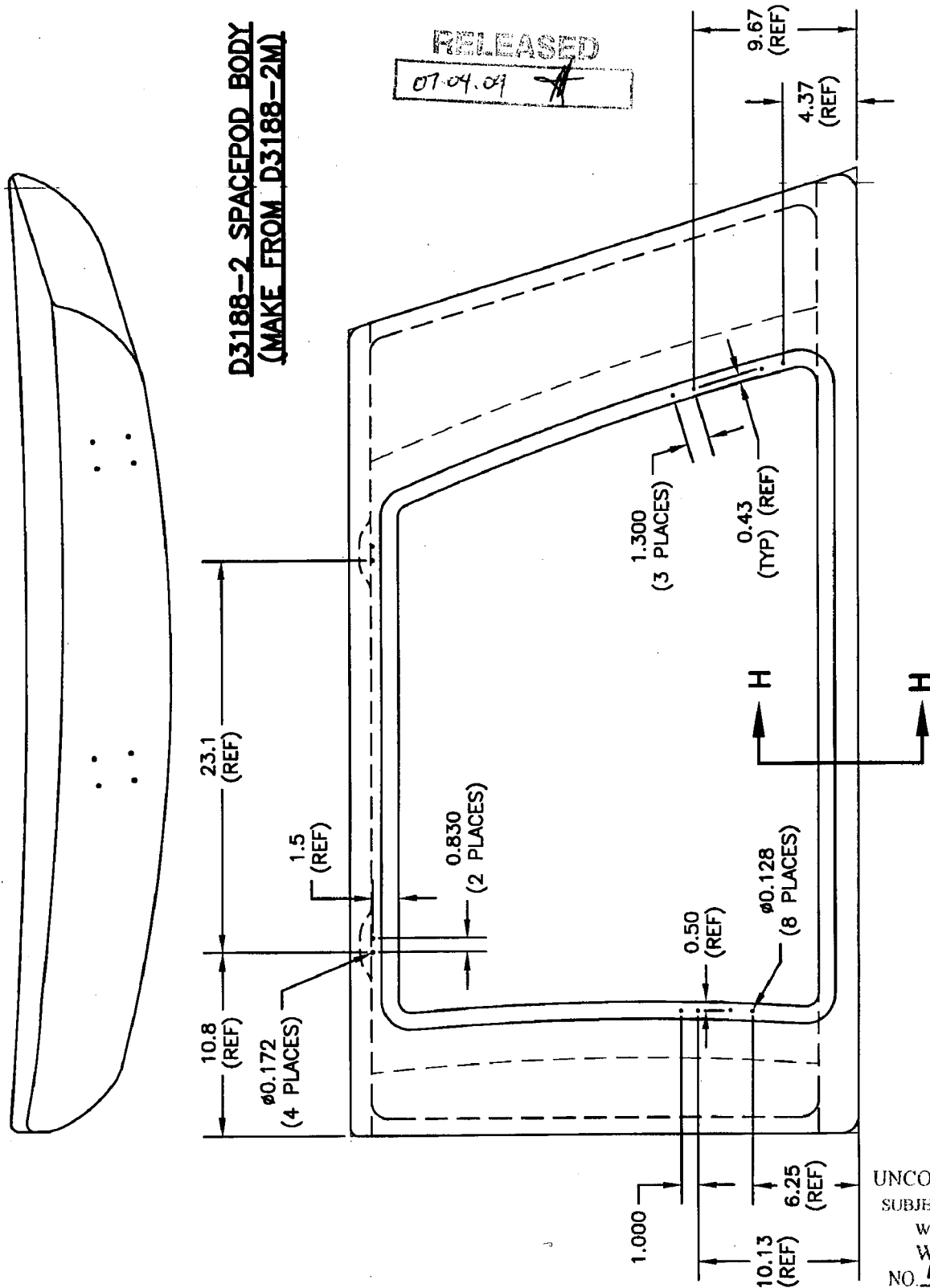
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| DATE 07.04.02 | | TITLE SPACEPOD BODY | SCALE NTS |

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

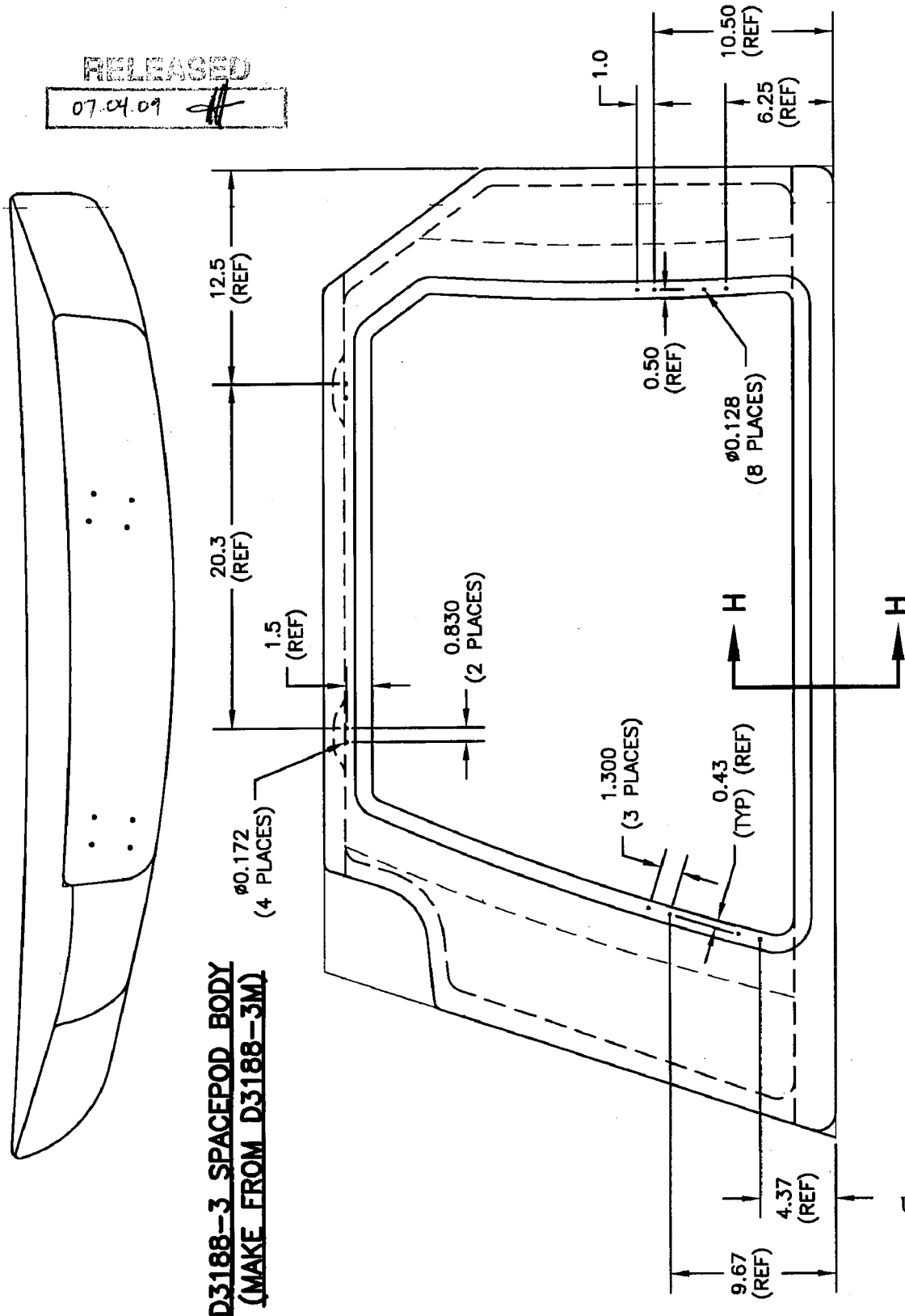
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| DATE 07.04.02 | | TITLE SPACEPOD BODY | SCALE NTS |

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
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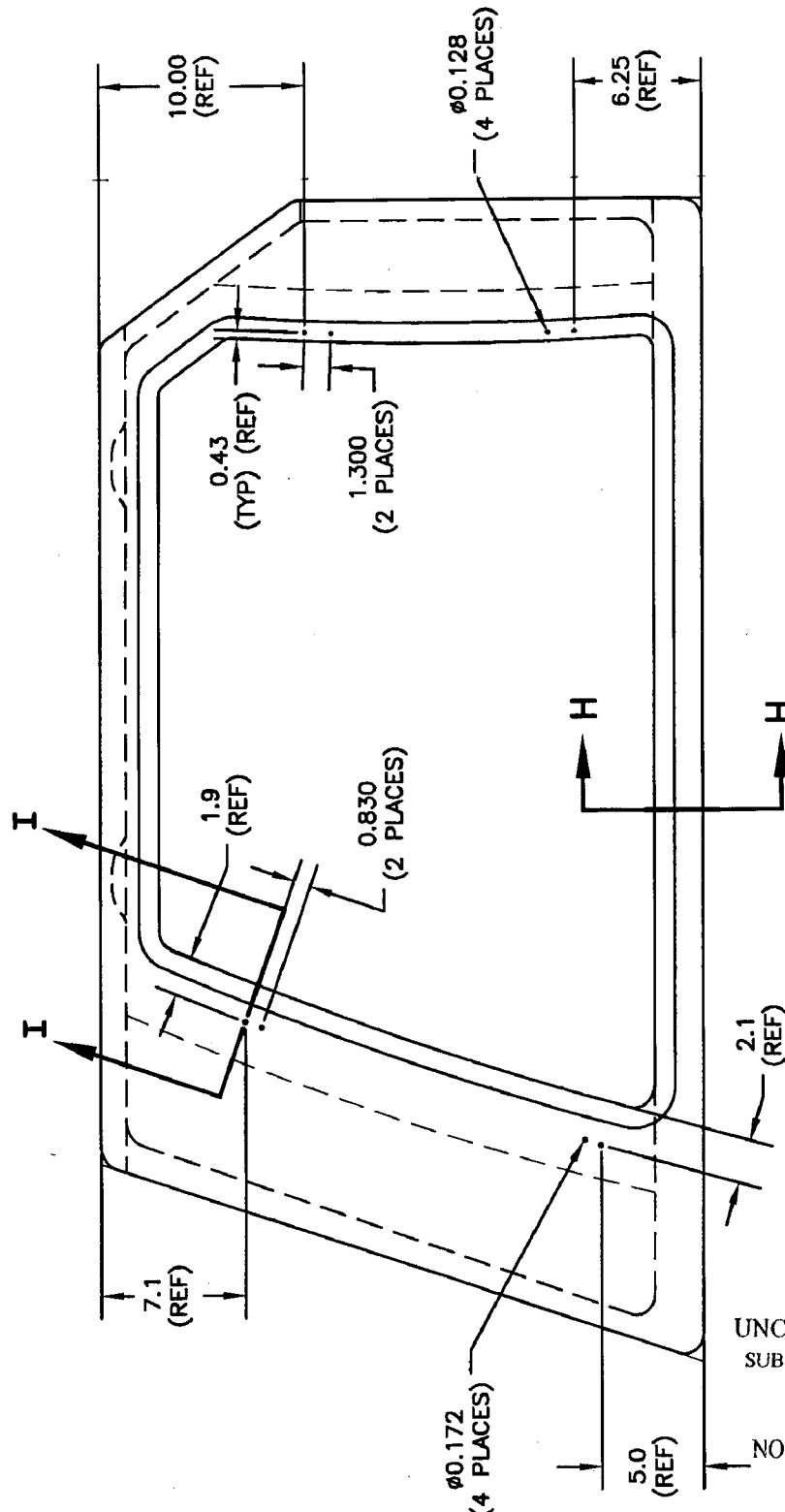
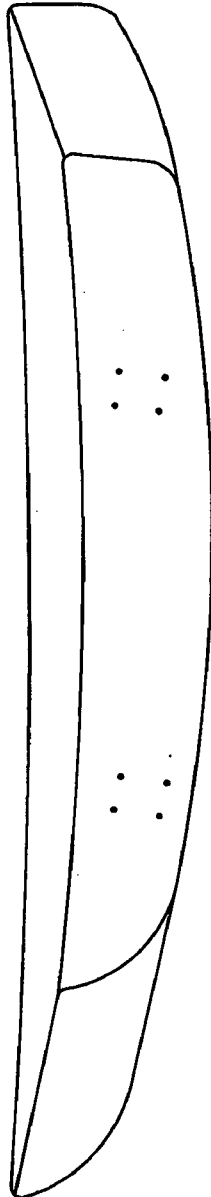
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**D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEWS

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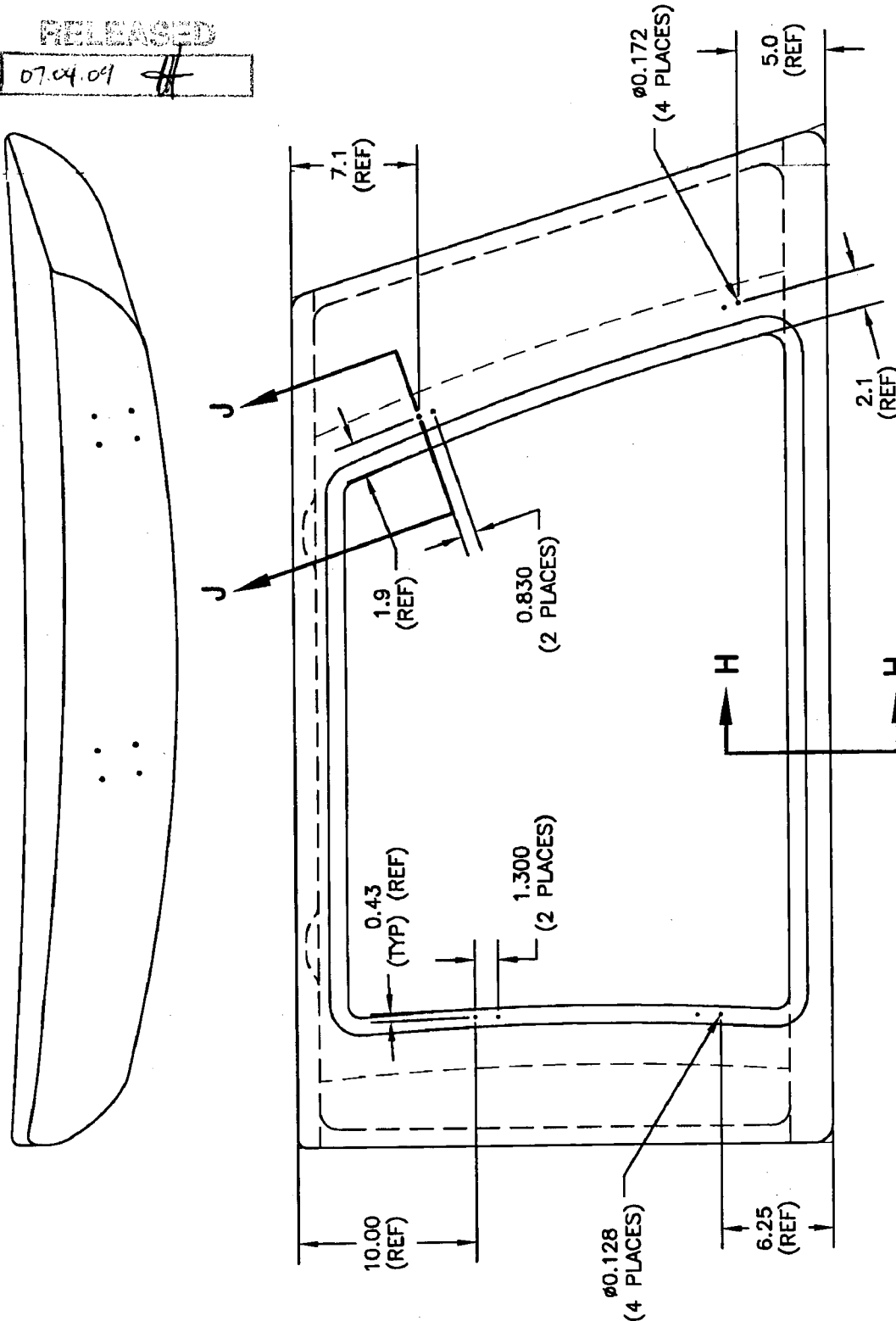


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| DATE 07.04.02 | | TITLE SPACEPOD BODY | SCALE NTS |

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07.04.09 H

**D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE

TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY

2) SEE SHEET #11 FOR SECTION VIEWS

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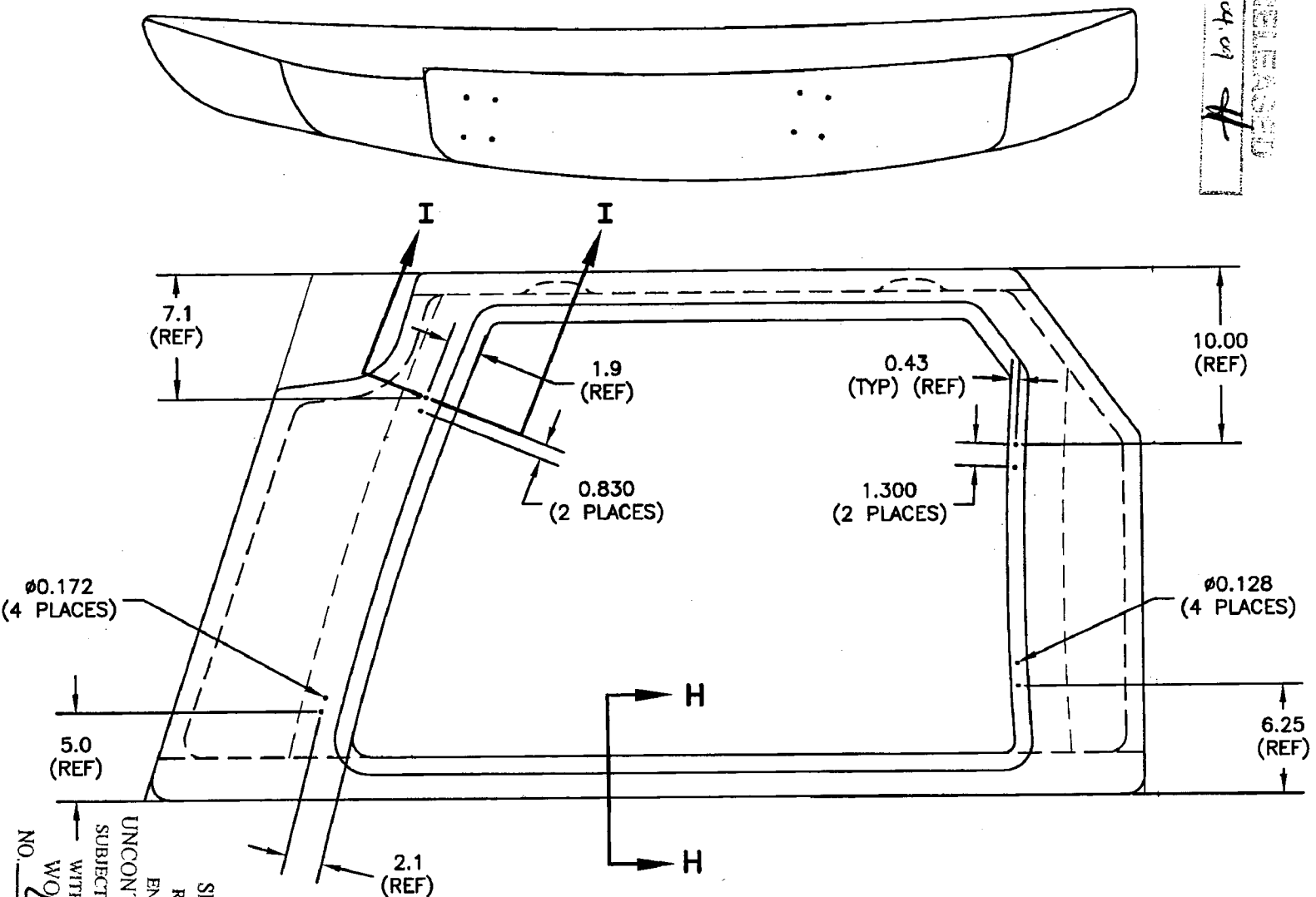
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| Ce | | D3188 | SHEET 10 OF 11 |
| DATE | TITLE | SCALE | |
| 07.04.02 | SPACEPOD BODY | NTS | |

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07.04.02

**D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)**



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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| DATE 07.04.02 | | TITLE SPACEPOD BODY | SCALE NTS |

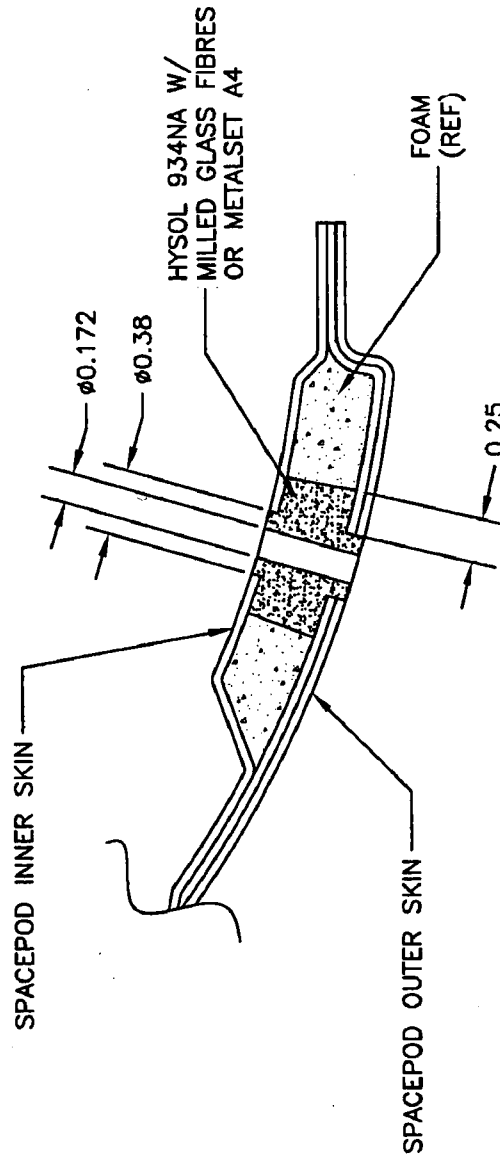
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01.04.09

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)

SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

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